

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002514**Date Inspected:** 02-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Deck Panels				

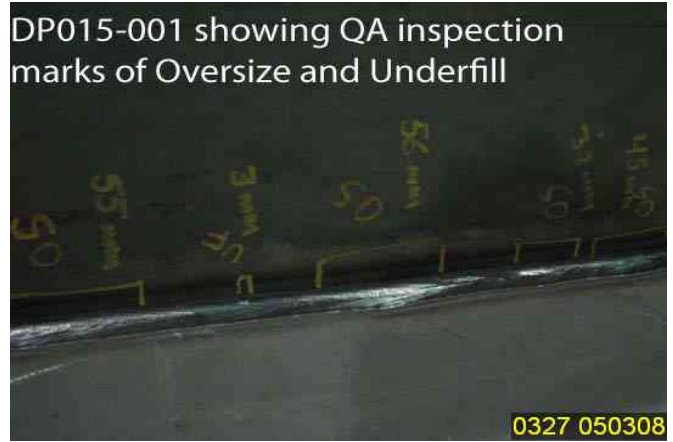
Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

QA Inspector completed visual verification inspection for completed Partial Joint Penetration (PJP) U-rib to deck plate welds on deck panel DP052-001 weld 010 and deck panel DP015-001 welds 002 thru 005. All welds that were inspected appeared to exhibit some degree of undercut, lack of fusion, overlap, oversize and/or under fill. All of the completed (PJP) welds joining U-Rib to deck plate that have inspected on these panels do not appear to comply with the visual acceptance criteria specified in AWS D1.5 2002 and the contract documents. DP052-001 has been rejected by ZPMC and ABF QC inspectors. DP015-001 was inspected by QA Inspector prior to ZPMC and ABF QC inspectors. QA Inspector completed Caltrans QA visual verification weld inspection reports for the OBG deck panels mentioned above. The report is on file in the Caltrans QA office.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
